

Date: * Monday, 02/03/2009 9:04:38 AM
 User: Julie Dawson

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASSY
Job Number	: 46128 -1		
Estimate Number	: 10675		
P.O. Number	:	Part Number	: D3443041
This Issue	: 02/03/2009 S.O. No. :	Drawing Number	: D3443 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 46127	Material	:
Written By	:	Due Date	: 23/03/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 09.03.02</u>		
Comment	: EST REV. A 05.11.17 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34431	Lug
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3443-1 lug B41913 x8 EL 9-3-2		
2.0	D34435	Tubing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3443-5 Tubing B46142 x2 EL 9-3-2		
3.0	D34531	Clevis
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3453-1 Clevis 1 x 34995 7 x B42178 EL 9-3-2		
4.0	238805	SS DOWEL PIN 3/4" LONG
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch 2 238-805 SS DOWEL PIN 3/4" LONG M105037 EL 9-3-2		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46128-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.03.19	5	length 8.54 is 0.060" below nominal (8.48) max i.e. Tolerance build-up from part to part.	CP 08.03.19 per AS/042	Acceptable. Small effect on position when assembled. makes tube stronger in bending & buckling	CP 9-3-19	CP 08.03.19 per AS/042	CP 08.03.19	CP 08.03.19

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46128

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



clean up



(8X)

Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3443

M106115

09/03/19

9-3-17

6.0

QC9

VISUAL WELDING INSPECTION



(X8)

Comment: VISUAL WELDING INSPECTION

09.03.19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.03.19 (8)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

8:45

OVEN TEMPERATURE:

400°

FINISH TIME:

9:15

LMD FL

09/03/24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09.03.24

(X8)

10.0

63215K32

Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

63215K32

Spherical Bearing

M111039 x4

09/03/24 (X8)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



FF

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

09/03/25 (1)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46128

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/05 ①

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location GA

GA SB 09/03/05 ①

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25 JF

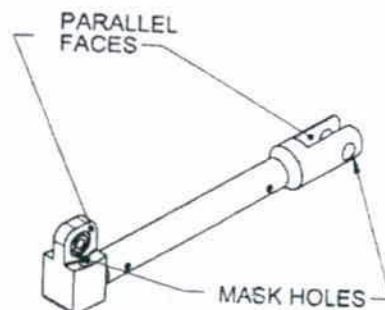
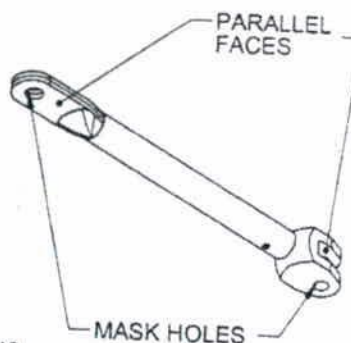
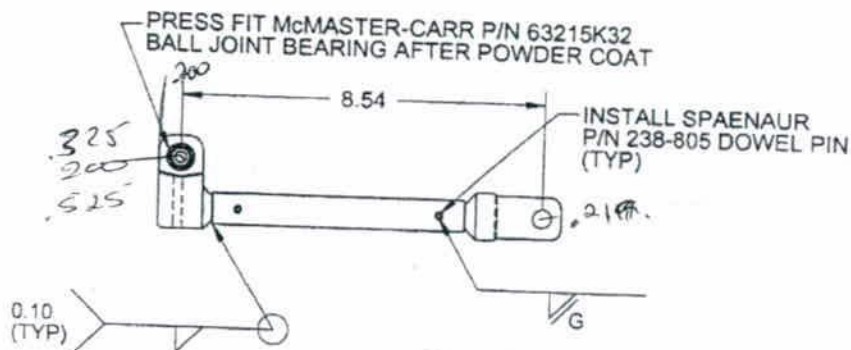
Job Completion:



mf
09.03.25

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED05.12.09 *[Signature]***D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARK

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *40128*

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